

Date: User:

Thursday, 24/07/2008 8:21:26 AM

Melanie Fauteux

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



21.0

PACKAGING

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: Vat

FINAL INSPECTION/W/O RELEASE



22.0

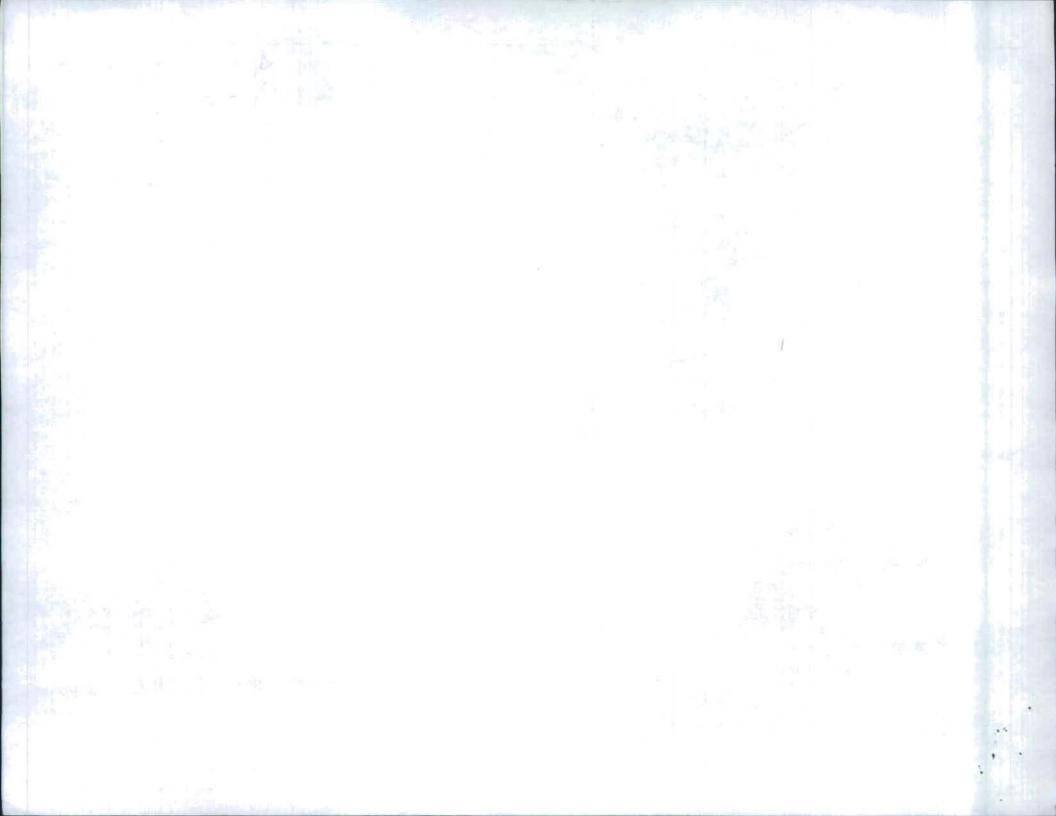
QC21



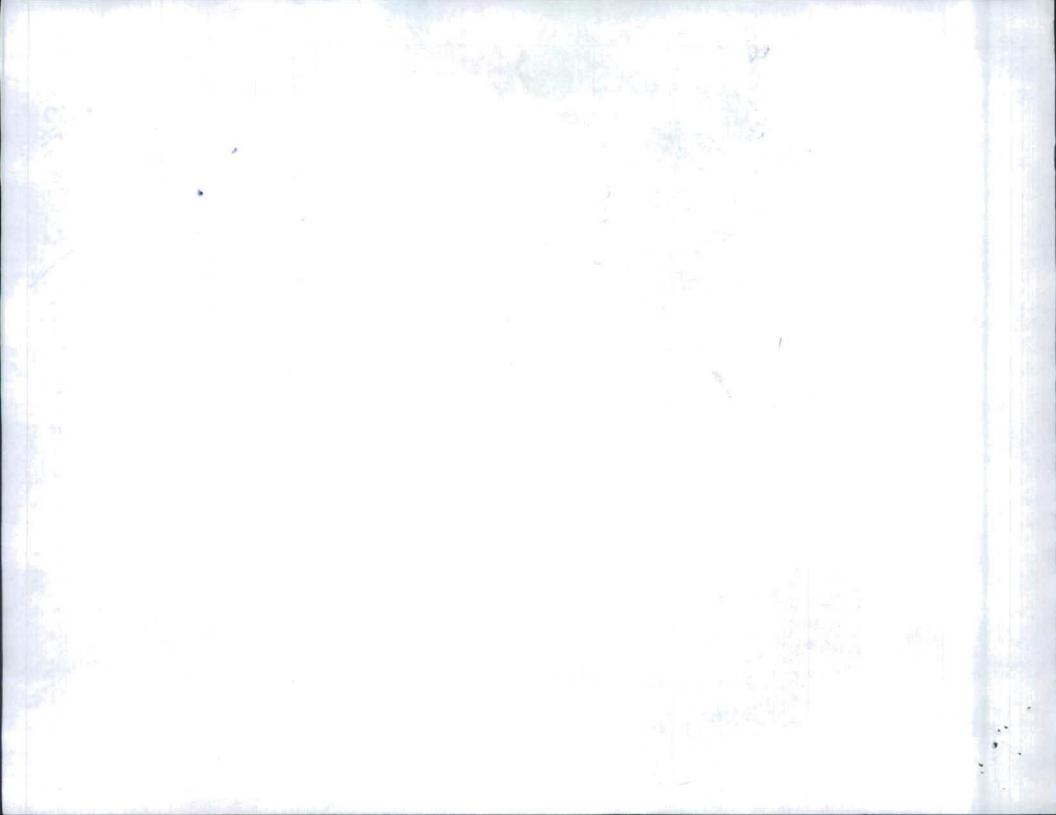
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

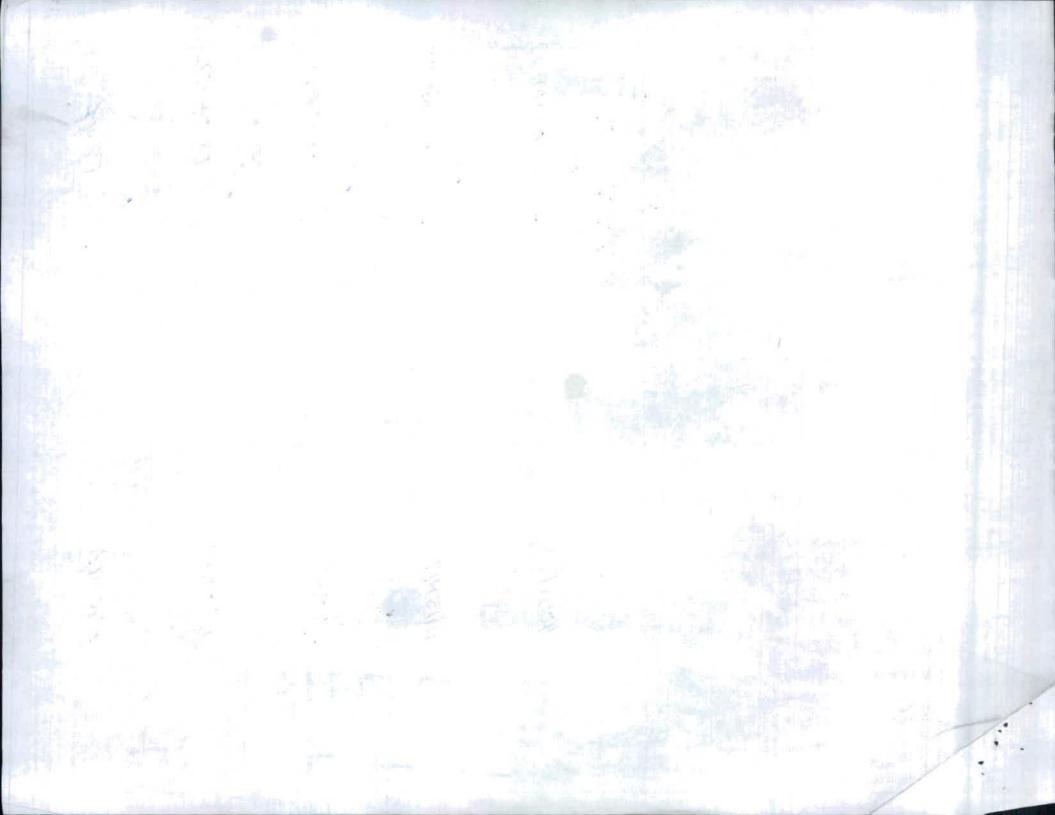




Date: Thursday, 24/07/2008 8:21:26 AM User: Melanie Fauteux **Process Sheet** Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services Job Number: 40607 Part Number: PB674300113 Job Number: Seq. #: Machine Or Operation: Description: START TIME: OVEN TEMPERATURE: FINISH TIME: QC3 14.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 15.0 PB674300169 90 Degree Cover Plate Comment: Qty.: 5.0000 Each(s) 1.0000 Each(s)/Unit Total: 90 Degree Coyer Plate batch: PB67-43001-83 16.0 PB674300183 Comment: Qty.: 5.0000 Each(s) Total: 1.0000 Each(s)/Unit PB67-43Q01-83 batch: MS27039110 17.0 Screw Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s) Screw batch: WASHER 18.0 NAS1149F0316 Comment: Qty.: 40.0000 Each(s) 8.0000 Each(s)/Unit Total: WASHER batch: 010903 SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 19.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 2- assemble as per dwg



Date: Thursday, 24/07/2008 8:21:26 AM User: Melanie Fauteux **Process Sheet** Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services Job Number: 40607 Part Number: PB674300113 Job Number: Seq. #: Description: Machine Or Operation: 6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg VISUAL WELDING INSPECTION QC9 7.0 08-07-29 (8 Comment: VISUAL WELDING INSPECTION INSPECT WORK TO CURRENT STEP 8.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 9.0 MS124780 HELICAL INSERT Comment: Qtv.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) HELICAL INSERT SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 10.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 2- tap drill for helicol 3- install helicol insert as per dwg 11.0 QC5 INSPECT WORK TO CURRENT Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 12.0 Comment: HAND FINISHING RESOURCE #1 08.01-31 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING POWDER COATING 13.0 02316 Comment: POWDER COATING 1- MASK TUBE FROM BASE TO GUSSET 2- Powder Coat Green Sandtex (Ref. 4.3.5.8) as per QSI 005 4.3 Page 2



Thursday, 24/07/2008 8:21:26 AM Melanie Fauteux **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services : AFT ADJUSTABLE BLADE SUPPORT ASSY **Drawing Name** Job Number : 40607 Estimate Number : 13436 P.O. Number Part Number : PB674300113 : 24/07/2008 This Issue S.O. No. : **Drawing Number** : B6743001 P.8 : NC Prsht Rev. : N/A Project Number : 17/07/2008 : LARGE FAB ASSY : B1 First Issue Type **Drawing Revision** Previous Run Material Qty: **Due Date** : 24/07/2008 Written By Checked & Approved By Comment : Est Rev:A 08-06-26 new issue DD verified by:ec **Additional Product** Job Number: Machine Or Operation: Seq. #: Description: PB6743001255 1.0 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

> Inner Tube, batch: 4059

2.0 PB6743001249

Inner Tube Bushing

Gusset

Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

> Inner Tube Bushing batch: M/8/19

PB6743001253 3.0



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

> Gusset batch:

4.0

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

> Gusset batch:

PB67430016 PB67-43001-67 5.0

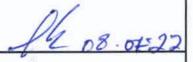


Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)









Each



